

In the Claims

1. A method of making an adhesive binder strip having a reduced transverse curl, said method comprising:
 - 5 providing an elongated substrate having a longitudinal axis and transverse axis normal to the longitudinal axis;
 - applying a layer of molten, heated-activated adhesive over a surface of the substrate;
 - cooling the layer of molten adhesive so that the layer is in a solid state;
 - 10 and
 - subsequent to the cooling and prior to application of the binder strip to a stack to be bound, mechanically deforming a surface of the layer of adhesive to a degree such that curling of the binder strip along the transverse axis is substantially reduced.
- 15 2. An adhesive binder strip made in accordance with the method of Claim 1.
3. The method of Claim 1 wherein the mechanically deforming includes
 - 20 applying multiple grooves to the surface of the layer of adhesive.
4. An adhesive binder strip made in accordance with the method of Claim 2.
- 25 5. The method of Claim 3 wherein the multiple grooves are applied in a direction substantially parallel to the longitudinal axis of the binder strip.
6. An adhesive binder strip for binding a stack of sheets comprising:

an elongated substrate having a longitudinal axis and a transverse axis normal to the longitudinal axis; and

5 a layer of heat activated adhesive disposed on a surface of the substrate, with the layer having an exposed surface containing deformities of a sufficient magnitude to substantially reduce curling of the binder strip along the longitudinal axis.

7. The adhesive binder strip of Claim 6 wherein the mechanical deformities include a multiplicity of grooves formed in the exposed surface.

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8. The adhesive binder strip of Claim 7 wherein the grooves extend at least 20% of the way through the total thickness of the adhesive layer.

9. The adhesive binder strip of Claim 8 wherein the grooves are disposed
15 in directions substantially parallel to the longitudinal axis.

10. The adhesive binder strip of Claim 6 wherein the mechanical deformities include a multiplicity of punctures in the exposed surface.

20 11. A method of binding a stack of sheets using a binding machine, said method comprising:

providing an elongated substrate having a longitudinal axis and transverse axis normal to the longitudinal axis;

25 applying a layer of molten, heated-activated adhesive over a surface of the substrate;

cooling the layer of molten adhesive so that the adhesive layer is in a solid state;

mechanically deforming an exposed surface of the layer to an extent such that curling of the substrate about the transverse axis is substantially reduced, thereby forming a binder strip; and

subsequent to the mechanically deforming, applying the binder strip to a
5 stack of sheets using a binding machine.

12. A binder strip formed in accordance with the method of Claim 11.

13. A method of making an adhesive binder strip having a reduced
10 transverse curl, said method comprising:

providing an elongated substrate having a longitudinal axis and transverse axis normal to the longitudinal axis;

applying a layer of molten, heated-activated adhesive over a surface of the substrate;

15 cooling the layer of molten adhesive so that the adhesive layer is in a solid state; and

subsequent to the cooling, forming a multiplicity of grooves in an exposed surface of the adhesive layer.

20 14. A binder strip made in accordance with the method of Claim 13.

15. A method of making an adhesive binder strip having a reduced transverse curl, said method comprising:

providing an elongated substrate having a longitudinal axis and
25 transverse axis normal to the longitudinal axis;

applying a layer of molten, heated-activated adhesive over a surface of the substrate;

cooling the layer of molten adhesive so that the adhesive layer is in a solid state; and

subsequent to the cooling, forming a multiplicity of punctures in an exposed surface of the adhesive layer.

- 5 16. A binder strip made in accordance with the method of Claim 15.
17. A method of making an adhesive binder strip having a reduced transverse curl, said method comprising:
- providing an elongated substrate having a longitudinal axis and transverse axis normal to the longitudinal axis;
- 10 applying a layer of molten, heated-activated adhesive over a surface of the substrate;
- cooling the layer of molten adhesive so that the adhesive layer is in a solid state; and
- subsequent to the cooling, forming a multiplicity of grooves in an
- 15 exposed surface of the adhesive layer, with the grooves extending at least 20% of the way through the thickness of the adhesive layer.
18. A binder strip made in accordance with the method of Claim 17.
- 20 19. An adhesive binder strip for binding a stack of sheets comprising:
- an elongated substrate having a longitudinal axis and a transverse axis normal to the longitudinal axis; and
- a layer of heat activated adhesive disposed on a surface of the substrate, with the layer having a multiplicity of grooves formed in an exposed
- 25 surface which extend at least 20% of the way through a thickness of the layer of adhesive.